

Work Order ID 82642

82642

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April-04-12 10:52:20 AM

Item ID: D4275-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Beam
 Start Date: 04/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 12/04/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4275	A								

100
100 BAND SAW 0.00
 Bandsaw 0.00 FK 12/05/12 4
 Jeaspa Bandsaw Memo
 Cut Blank to 39.750"
 Batch: 121380

110
110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS I 0.00 FK 12/05/13 4
 HAAS CNC vertical machine #1 Memo
 1-Machine per folio FB006
 DWG REV: A
 FOLIO REV: A
 2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		FK 12/05/13		4			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Zg 12-5-15		4			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	1/6	12-5-16	

W/O:		WORK ORDER CHANGES					
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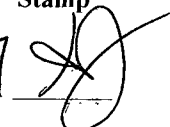
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/5/17 
 MC
 12-05-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82642

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Parent Item: D4275-1

D4275-1

Parent Item Name: Fwd Beam

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP
rev:B 10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	43.0140	3.3125	13.94737			

M6061T6B1 000X04 000

**

6061-T6 Bar 1.00 x 4.00

Location	Loc Qty	Loc Code
MAT004	11.1	
116808	0.787	
118400	15.003	
119346	2.554	
120243	1.57	
120603	11.1	
120866	12	
121380		

13.948 FK 12/05/12.

W/O:		WORK ORDER CHANGES					
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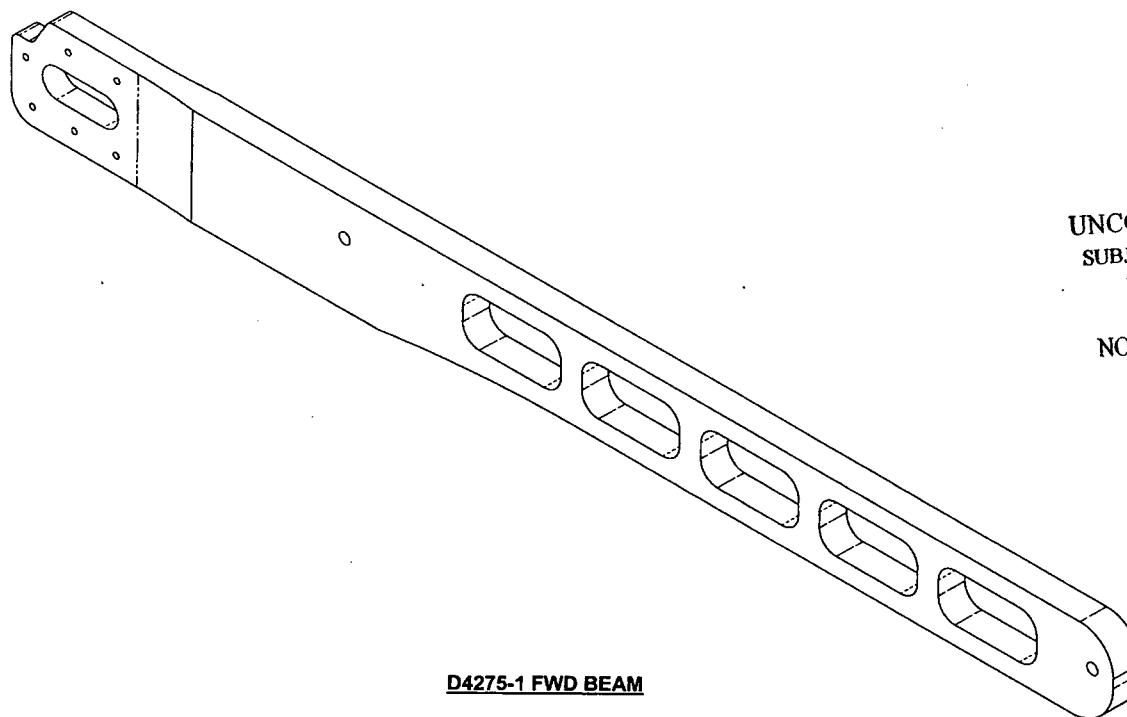
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82642
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.751	✓		FK-04	Vern
26.700	+/-0.010	26.4	✓		FK-05	Tape
Ø0.381	+0.000/-0.001	.381	✓		FK-01	Mic.
8.280	+/-0.010	8.280	✓		FK-05	Tape
1.44	+/-0.030	1.44	✓		FK-04	Vern
0.95	+/-0.030	.95	✓		"	"
3.50	+/-0.030	3.502	✓		"	"
13.28	+/-0.030	13.28	✓		FK-05	Tape
13.50	+/-0.030	13.50	✓		"	"
9.25	+/-0.030	9.25	✓		"	"
5.00	+/-0.030	5.00	✓		FK-04	Vern
0.75	+/-0.030	.75	✓		"	"
2.75	+/-0.030	2.75	✓		"	"
3.00	+/-0.030	3.002	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
4.50	+/-0.030	4.470	✓		"	"
0.734	+/-0.010	.731	✓		"	"
0.108	+/-0.010	.105	✓		31006	Height gauge
39.48	+/-0.030	39.48	✓		FK-05	Tape
0.95	+/-0.030	.940	✓		FK-04	Vern
0.60	+/-0.030	.598	✓		"	"
1.750	+/-0.010	1.750	✓		"	"
2.700	+/-0.010	2.697	✓		"	"
1.10	+/-0.030	1.10	✓		"	"
1.25	+/-0.030	1.245	✓		"	"
0.900	+/-0.010	.900	✓		31006	Height gauge
0.75	+/-0.030	.750	✓		FK-04	Vern
0.250	+/-0.010	.250	✓		31006	Height gauge
3.000	+/-0.010	3.000	✓		FK-04	Vern
1.500	+/-0.010	1.500	✓		"	"
Ø0.191	+0.005/-0.001	.192	✓		"	"



D4275-1 FWD BEAM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82642 MLJ
12/04/04

RELEASED
2010-11-30
JMB

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4275	REV. A
MFG. APPR.	JPH	TITLE	SHEET 1 OF 2
APPROVED	JPH	FWD BEAM	SCALE
DE APPR.	JPH		NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

